



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB877212-08-17
Job Sheet 192389



Part No: RB877212-08-17

Job Qty: 2 pcs

Part Name: R&I Adapter, Ø1-5/8 x 1-1/2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
110	SL-2500Y - 1	2 pcs	5/3/19	5/3/19	0.00	1.00	SL-2500Y - 1 154-1	JB 19-04-30
120	QC 2	2 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	JB 19-04-30
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S176357



Part: RB877212-08-17

Job No: 192389

Serial No/Batch: S176357

Revision: D

Inspector:

Exp Date:

Inspection No:

Date: 04/30/19

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130 QC 8	2 pcs	5/3/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-04-30
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
132 Outsource - 12 - Black Oxide	2 pcs	5/3/19		GRO002-VC	10 2019-05-02
134 Packaging 2-1 - Receive - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP MAY 10 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	

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				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
136 QC 6	2 pcs	5/3/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	MAY 13 2019 68
				QC 6 - 61	9-89
140 Packaging 3-1 - Stock - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	2 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 110 - 1-Machine as per DWG. FC <u>733</u> FOLIO REV: <u>AA</u> DWG REV: <u>D.</u> 2-Deburr Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 132 - Outside Processing - Black Oxide -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 134 - Receive & Inspect for Damage & Mat'l Certs 136 - QC6- All purchased or subcontracted products 140 - Identify as per dwg & Stock Location: _____ 150 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-1144-R1.750	AISI 1144 Stressproof Round Bar 1.750"	.2840 ft (.142 ea)	110-SL-2500Y - 1	<u>5018005</u>	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y-1 154-1	MT-1144-R1.750	0	7	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

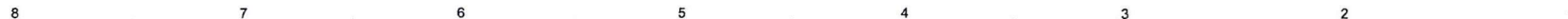


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



C



A

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB877212-08 TITLE TAIL ROTOR BEARING CUTTER COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTAINS UNCLASSIFIED BUT PROPRIETARY INFORMATION THAT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. 1
DRAWN	MBB		SHEET 8 OF 8
CHECKED	MBB		SCALE
MFG. APPR.	DP		NTS
APPROVED	<i>[Signature]</i>		
DATE 3/21/2019			

A



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043359



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043359

PO Date: 5/2/19

Due Date: 5/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186487	RBT400313-1	Adapter Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X11	-	5/10/19 MAY 10 2019	11 pcs	0 pcs	11 pcs	\$9.55/pcs	\$105.05
2	193407	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X24	-	5/10/19 MAY 10 2019	24 pcs	0 pcs	24 pcs	\$2.80/pcs	\$67.20
3	192391	RB877212-08-1	Shaft, Ø3/4 x 4 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed X6	-	5/10/19 MAY 10 2019	6 pcs	0 pcs	6 pcs	\$1.02/pcs	\$6.12



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	192393	RB877212-08-27	Bolt, 1/2-20 UNF x 3-1/4 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	5/10/19	6 pcs	0 pcs	6 pcs	\$1.02/pcs	\$6.12
				X6		MAY 10 2019			DP		
5	192389	RB877212-08-17	R&I Adapter, Ø1-5/8 x 1-1/2 Outside Processing - Black Oxide -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	5/10/19	6 pcs	0 pcs	6 pcs	\$1.60/pcs	\$9.60
				X6		MAY 10 2019			DP		
6	193363	RBE350A93-3307-00-01	Retractor -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	5/10/19	18 pcs	0 pcs	18 pcs	\$2.55/pcs	\$45.90
				X18		MAY 10 2019			DP		
Grand Total:										\$239.99	

DAS
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PURCHASE ORDER

POHB043359



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in blue ink, appearing to be "JH".

Plex 5/3/19 9:26 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(018930-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.grouppaltech.com

Bon de Livraison / Packing Slip

018930- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

RECEIVED
 MAY 10 2019
 DART AEROSPACE LTD.

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
10-May-2019		Jessie Boisvert			POHB043359				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBT400313-1 Rev.	RBT400313-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	11	11	0	0	0	
2	RBE350A94-3700-A-05 Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0	
3	RB877212-08-1 Rev.	RB877212-08-1 01 -BLACK OXIDE ON SST MIL-DTL-13924D CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-C-81309 OR MIL-C-81309 TYPE 3 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0	
4	RB877212-08-27 Rev.	RB877212-08-27 01 -BLACK OXIDE ON SST MIL-DTL-13924D CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-C-81309 OR MIL-C-81309 TYPE 3 AND WIPE OFF EXCESS	BLACK-OXIDE CH	6	6	0	0	0	
5	RB877212-08-17 Rev.	RB877212-08-17 R&I ADAPTER 01 - BLACK OXIDE ON SST MIL-DTL-13924D OUTSIDE PROCESSING - BLACK OXIDE BLACK OXIDE FINISH MIL-C-13924 CLASS 1	BLACK-OXIDE CH	6	6	0	0	0	
6	RBE350A93-3307-00-01 Rev.	RBE350A93-3307-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C13964 CLASS 1 , MIL-C-16173 GRADE 4	OXIDE-BLACK CH	18	18	0	0	0	

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9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.